

Work Order ID 153062

Monday, November 07, 2016 4:09:02 PM

153062

Page 1

Item ID: D3783-041 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Lateral Brace Assembly
Start Date: 11/2/2016 Start Qty: 2.00 ***2*** Cust Item ID:
Required Date: 11/7/2016 Req'd Qty: 2.00 ***2*** Customer:
Reference:

Approvals: Process Plan: DAS Date: NOV 09 2016 Tooling: _____ Date: _____ Run Start ***NR1***
QC: 21 Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***
9-89

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3783	Rev A ✓								
100	Pick Kit	0.00							
100									
Packaging	Memo	0.00							
Packaging									
110		0.00							
110	Small Fab								
Small Fab	Memo	0.09							
Small Fab	1-assemble as per dwg D3783								
120	QC5- Inspect part completeness to step on W/O	0.00							
120									
QC	Memo	0.01							
Quality Control									

2 NOV 17 2016 DAS
6
9-89

2 FF NOV 18 2016

2 DAS
38
9-89
NOV 18 2016

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition			Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
		OTHER : _____			

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
124 *124* Powdercoat Powder Coating	Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3 <i>N 134858.</i> Memo ***Mask inside D3765-1 clevis*** POWDER COAT: Start Time: <i>9:10</i> Oven Temperature: <i>320°</i> Finish Time: <i>9:40</i>	0.00 0.01				<i>2</i>	<i>0</i>	<i>16-11-23</i>	<i>DAS 34 9-89</i>
127 *127* QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00				<i>2</i>			<i>DAS 38 9-89</i> <i>NOV 23 2016</i>
130 *130* Packaging Packaging	Identify as per dwg & Stock Location: <i>51250</i> Memo	0.00 0.00				<i>2</i>		<i>NOV 13 2016</i>	<i>DAS 6 9-89</i>

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WORK ORDER NON-CONFORMANCE / UPDATE



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Item ID: D3783-041

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Lateral Brace Assembly

Start Date: 11/2/2016 Start Qty: 2.00

2

Cust Item ID:

Required Date: 11/7/2016 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

140

QC21- Final Inspection - Work Order Release

0.00

140

QC

Memo

0.03

Quality Control

DAS
21
9-89

NOV 23 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
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Picklist Print

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153062

Parent Item: D3783-041

D3783-041

Parent Item Name: Lateral Brace Assembly

Start Date: 11/2/2016

Required Date: 11/7/2016

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev:A 08-05-19 new issue DD verified by:ec
IPP Rev:B 08-06-17 rev.a as per dwg DD verified by:EC IPP RevC: add
powder coat for ease of manufacturing DD 10.01.13 verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

AN5-13A

Purchased

No

110

Each

50.0000

2

4

AN5-13A

BOLT

**

NOV 17 2016

DAS
6
9-89

Location

Loc Qty

Loc Code

over003

20

m135530

20

ST338

30

m135464

10

m136044

20

D3765-1

Manufactured

No

110

Each

6.0000

2

4

D3765-1

Clevis

**

NOV 17 2016

DAS
6
9-89

Location

Loc Qty

Loc Code

ST251

6

150451

6

D3769-1

Manufactured

No

110

Each

4.0000

1

2

D3769-1

Tube

**

NOV 17 2016

DAS
6
9-89

Location

Loc Qty

Loc Code

ST254

4

124614

4

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

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		OTHER : ☐							

Picklist Print

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Parent Item: D3783-041

D3783-041

Parent Item Name: Lateral Brace Assembly

Start Date: 11/2/2016

Required Date: 11/7/2016

Start Qty: 2.00

Required Qty: 2.00

MS21042L5 Purchased No

110 Each 308.0000 2 4

MS21042L5

Nut

Location	Loc Qty	Loc Code
GA	25	
m127813	25	
ST303	283	
m135297	113	
m135544	100	
m135774	70	

NOV 17 2016

DAS
6
9-89

NAS1149D0563J Purchased No

110 Each 1,173.000 4 8

NAS1149D0563.J

Washer

Location	Loc Qty	Loc Code
GA	69	
m125807	2	
m133769	67	
ST263	1005	
m126319	28	
m135470	277	
m135774	700	
ST269	99	
m128257	99	

NOV 17 2016

DAS
6
9-89

DQA: _____ Date: _____



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Description Work Order Deviation				Disposition					
								Completed By	
								Lead hand / Supervisor Approval Verification	
QC / QA Coordinator Approval									

Root Cause				FAULT CATEGORY							
Environment	☐	No Re-verification	☐	Pressure/Forced	☐	Temperature/Cure	☐	Power Loss/Surge	☐	Positioned Wrong	☐
Design	☐	Operator	☐	Bending	☐	Set-up	☐	Folio/Program	☐	Outside Dimensions	☐
Doc/Data	☐	Offset/Setup	☐	Centre Not Concentric	☐	BOM/Route	☐	Grain	☐	Over/Under tolerance	☐
Equip/Tooling	☐	Supplier	☐	Cracks	☐	Broken/Damage/Defect	☐	Weld	☐	Part Incorrect	☐
Handling/Pre	☐	Training	☐	Crimp/Kink/Ripple/Wave	☐	Inspection Incomplete/Unqualified	☐	Wrong Stock Pulled	☐	Part Lost/Missing	☐
Material	☐	Use for Testing	☐	Cuffs	☐	Contamination	☐	Out of Sequence	☐	Part Moved	☐
Internal Transport	☐	Poor Information	☐	Crushing	☐	Countersink	☐	Off-set	☐	Drawing	☐
Tribal Knowledge	☐	Rushing	☐	Heat Treat	☐	Cut Too Short	☐	Mislabeled	☐	Finish	☐
LOA	☐	Product Improvement	☐	Wave/Twist in Tube	☐	Instructions Incomplete/Unclear	☐	Fit/Function	☐	Misread	☐
Substation	☐	Process Improvement	☐	Marks/Chatter	☐	Drill Holes	☐	Misaligned/off center	☐	Turning Sequence	☐
Past Expiry Date	☐	Manufacturing Process	☐	OTHER : _____							
Misidentified	☐	Past Due	☐								